

Work Order ID 65690

January 21, 2011 2:27:00 PM



Page 1

Item ID: D4306-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib

Start Date: 1/21/11

Start Qty: 100

Req'd Qty: 100

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4306

B

100

0.00



Large Fab

Large Fab

Memo

0.00

1- Cut tube 50"
2- Bend tube with manuel pipe bender as per DT9567
*** Make line at 9.00" and use jig for other lines, and ensure seam in place on
side of tube when bending***
3- Trim access tube material to finish size as per dwg D4306

SAD 11-01-25

(2)

PTO
→

110

QC6- Inspect dimensions to drawing

0.00



QC

Quality Control

Memo

0.00

Sad 11-01-25

(x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4306-1 PAR #: _____ Fault Category: Large Fab NCR: Yes No DQA: _____ Date: 11/01/25
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: _____ Date: 11/01/26

NCR: <u>65690</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/01/25</u>	<u>#100</u>	<u>Scrap one Part, Part Slipped in bender when bending Part got over bend by 1/4" R.L. Process</u>	<u>[Signature]</u>	<u>-Scrap + Destroy Qty x1 no replace.</u>	<u>SAD</u> <u>11-01-25</u>	<u>[Signature]</u> <u>11/01/25</u>	<u>[Signature]</u> <u>11/01/25</u>	<u>[Signature]</u> <u>11/01/25</u>

NOTE: Date & initial all entries

Work Order ID 65690

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Item ID: D4306-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib

Start Date: 1/21/11 Start Qty: 1.00



Cust Item ID:

Required Date: 1/26/11 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



Packaging

Identify as per dwg & Stock Location: *B/C*

0.00

Memo

0.00

EPC 11-01-26

Packaging

130



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

*11/01/26**PS 11-01-26*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 65690

Parent Item: D4306-1

Parent Item Name: Rib



Start Date: 1/21/11

Required Date: 1/26/11

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.01.20 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.049		Purchased	No			100	f	138.7183	4.1666	4.385895			



304 SQ Tube .75x.75x.049W



SAD 11-01-25

Location	Loc Qty	Loc Code
MAT	94.19066794	
113763	0	
114323	8.15031894	
114677	0.00001	
114835	0.000039	
116319	32.7652	
116509	53.2751	
MAT017	3.68448E-05	
114298	3.6845E-05	
WA	44.5276	
114992	11.2825	
115260	33.2451	

8.77

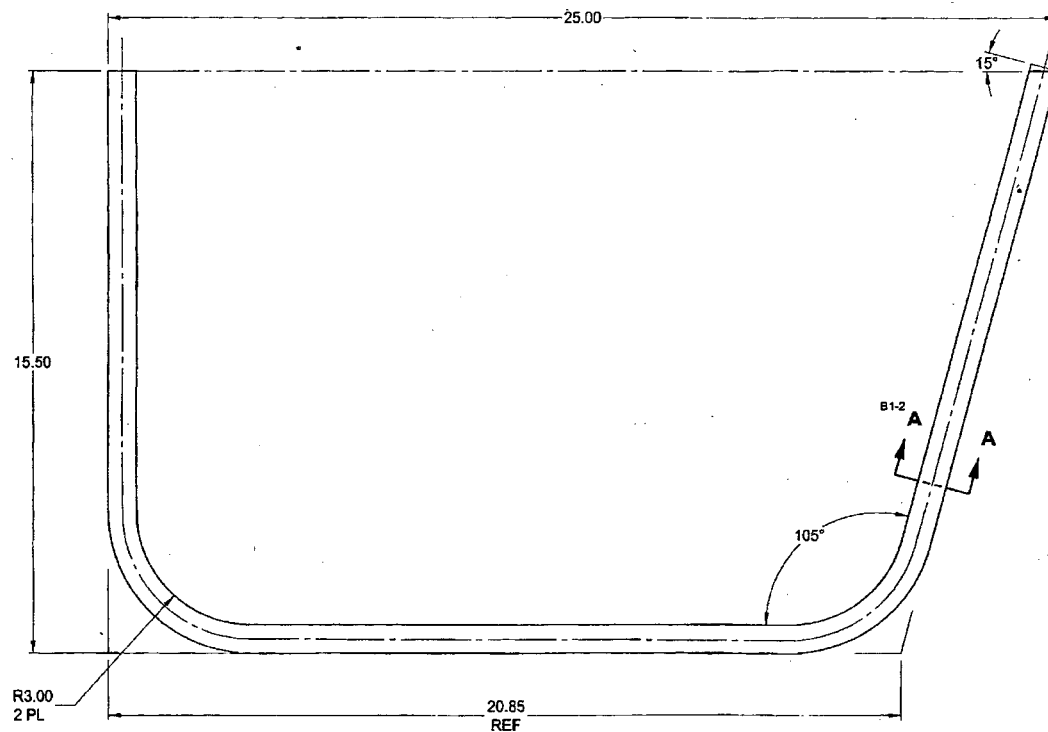
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

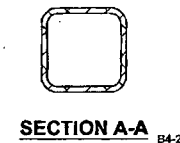
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4306-1 RIB



RELEASED
2011-01-18

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) TUBE FLAT LENGTH 50.0 REF

W/O 65690

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO. D4306	REV. B
MFG. APPR.			SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		RIB	NTS
DATE	10.12.17	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

